




# Work Order ID 55755




January 29, 2010 11:19:09 AM



Page 1

Item ID: D2989-043 Accept  Setup Start   
Revision ID: Stop   
Item Name: Basket Lid Assembly  
Start Date: 1/29/10 Start Qty: 1.00  Cust Item ID:  
Required Date: 2/08/10 Req'd Qty: 1.00  Customer:

## Reference:

Approvals: Process Plan:  Date: 10-1-29 Tooling: Date: Run Start   
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100

0.00




Large Fab

Large Fab

## Memo

0.00

1- assemble all ribs in DT9446 jig, weld as per dwg D2989  
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig  
3- to locate hinges and shims use D2989-041, weld as per dwg D2989  
A/R ER316 S.S. Rod Batch: H109213

 10/02/11 (1x)  
10.02.09

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00




QC

## Memo

0.00

Quality Control

 10/02/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55755

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Page 2

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 1/29/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

*5/6/02/16*



QC

Memo

0.00

*(70)*

Quality Control

130

*pressure wash*  
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

*M113170*



Powdercoat

Memo

0.00

*7/11/10 10/02/16*

*(X) (X)*

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

*11:30AM*

OVEN TEMPERATURE:

*400°F*

FINISH TIME:

*11:30AM*

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

*12:00pm*

OVEN TEMPERATURE:

*400°F*

FINISH TIME:

*12:30pm*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55755

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Page 3

Item ID:	D2989-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	1/29/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/08/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							
			= 7 m-h 10/02/16 (1X)						
150  Packaging Packaging	Identify as per dwg & Stock Location: <del>GA</del> GA Memo	0.00 0.00							
			SAD 10-02-16 (1)						
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							
			10/02/18 ME 10-2-17						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

January 29, 2010 11:19:14 AM

Work Order ID: 55755

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 1/29/10

Required Date: 2/08/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1 Manufactured No 100 Each 11.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

10

53662

10

PD 10.02.08

D2989-3 Manufactured No 100 Each 4.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

53551

2

54276

2

PD 10.02.08

D2989-4 Manufactured No 100 Each 4.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

53552

2

54277

2

PD 10.02.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January 29, 2010 11:19:14 AM

Work Order ID: 55755



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 1/29/10

Required Date: 2/08/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2989-5 Manufactured No 100 Each 6.0000 2.0000



Rib

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
53553	2	
54226	4	

PD 10.02.08

D3182-1 Manufactured No 100 Each 12.0000 2.0000



Hinge

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	12	
53445	12	

PD 10.02.09

D3442-3 Manufactured No 100 Each 8.0000 2.0000



Shim

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
42718	1	
53137	7	

PD 10.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 29, 2010 11:19:14 AM

Work Order ID: 55755



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 1/29/10

Required Date: 2/08/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3827-041 Manufactured No 100 Each 5.0000 1.0000



Rib Assembly (Inboard)



Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST 5

53901 5

PD 10.02.08

D3832-5 Manufactured No 100 Each 4.0000 1.0000



Mesh (Lid)



Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST 4

52049 1

53220 3

PD 10.02.09

D3833-5 Manufactured No 100 Each 25.0000 2.0000



Mesh (Lid End)



Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST 25

51305 4

53722 21

24 SH 10/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 4

January 29, 2010 11:19:14 AM

Work Order ID: 55755



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 1/29/10

Required Date: 2/08/10

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3838-041 Manufactured No 100 Each 4.0000 1.0000



Rib Assembly (Basket Lid, LH)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

53550

2

54274

2

PD 10.02.08

D3838-042 Manufactured No 100 Each 4.0000 1.0000



Rib Assembly (Basket Lid, RH)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

53549

2

54275

2

PD 10.02.08

January 29, 2010 11:19:14 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55755  
M10-1-29



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

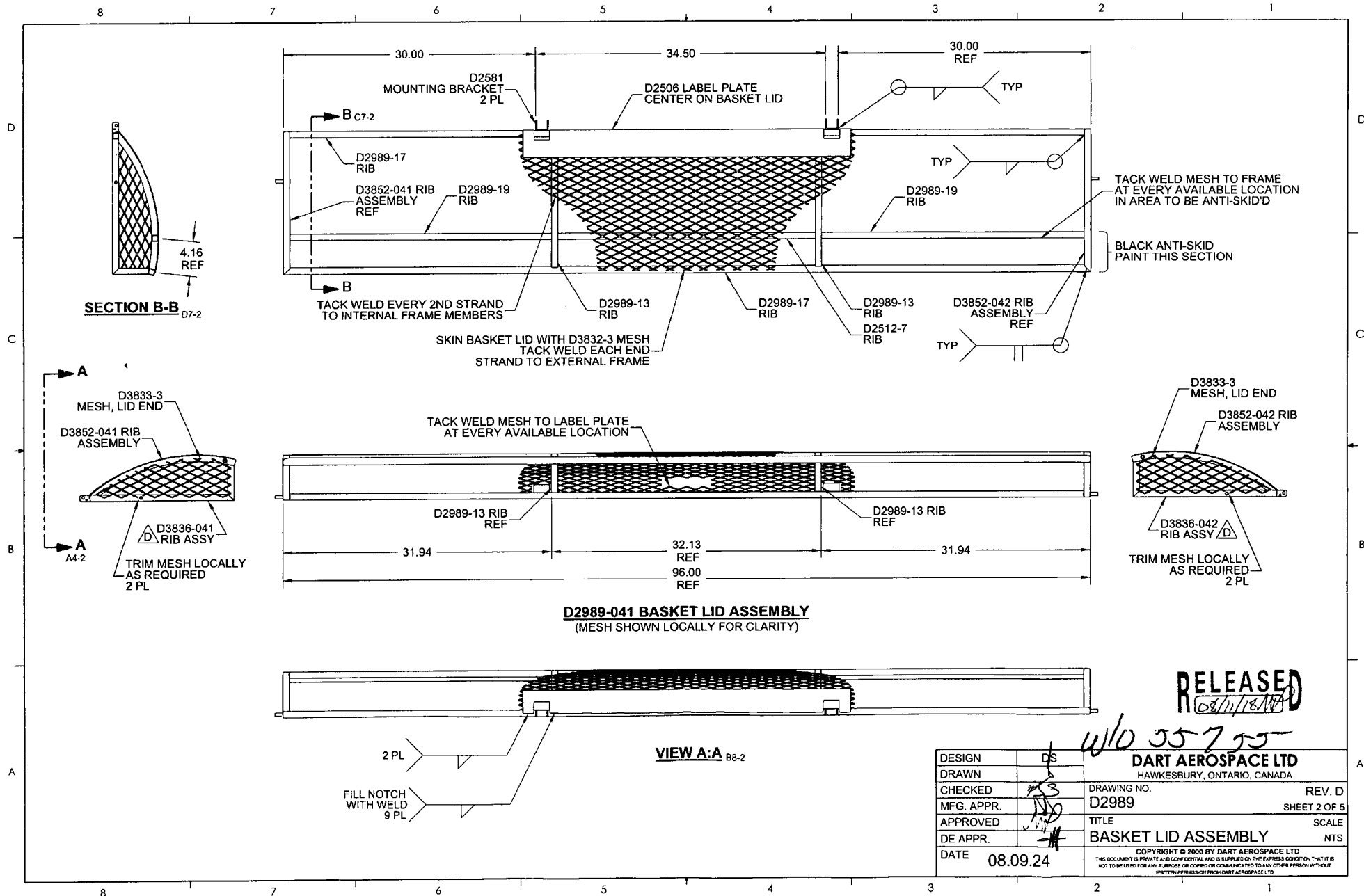
RELEASED  
08/11/81

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED	DS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

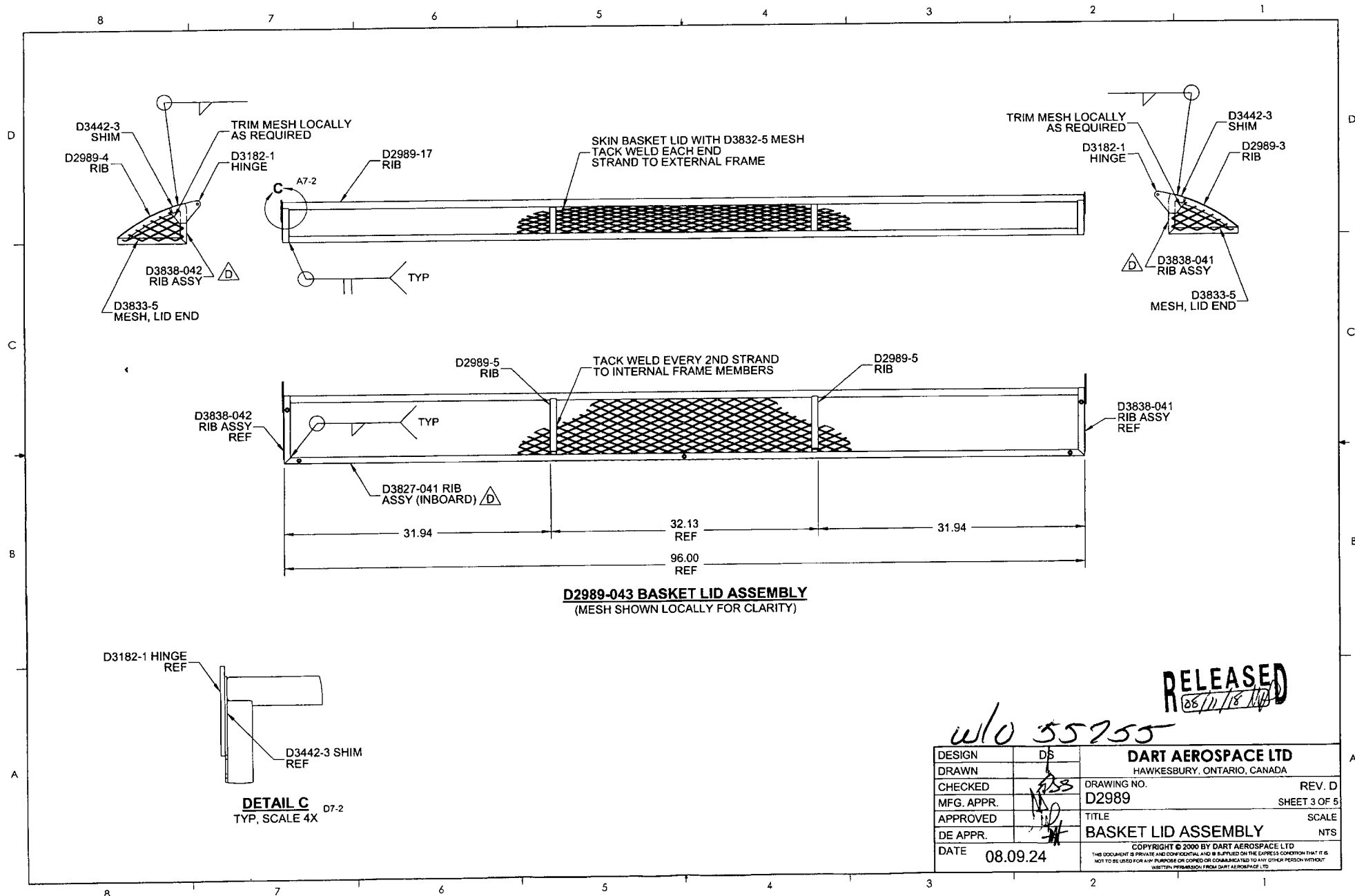
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D  
**D2989**  
SHEET 1 OF 5  
TITLE SCALE  
**BASKET LID ASSEMBLY** NTS

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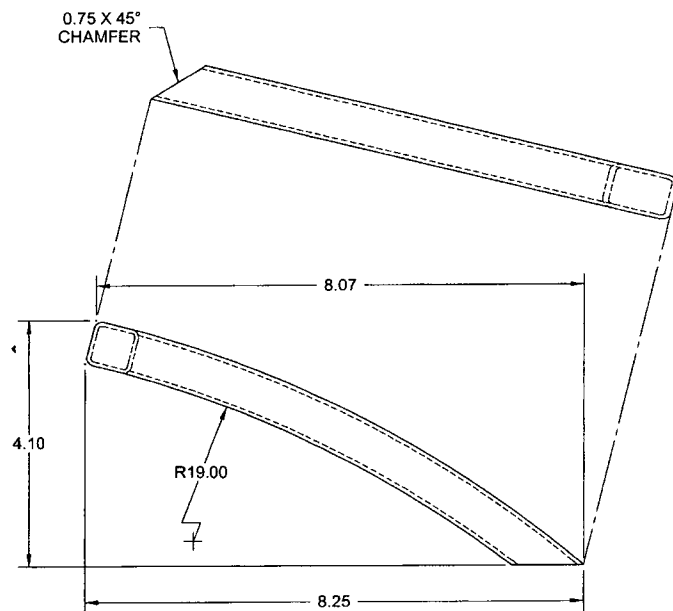




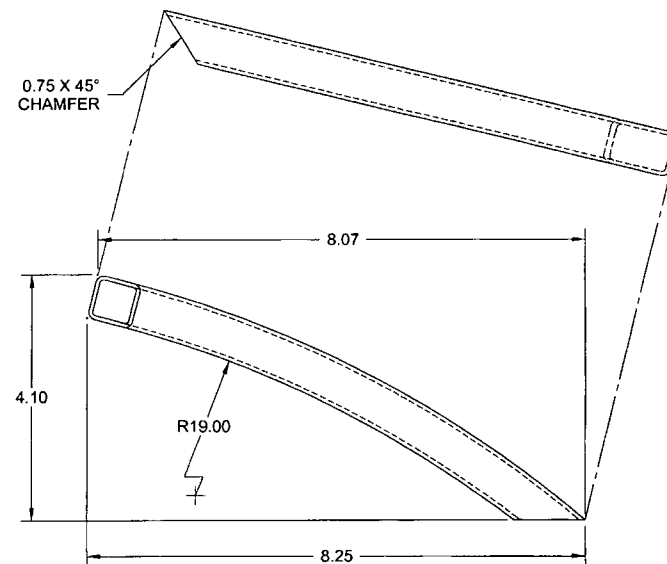
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w/o 55755

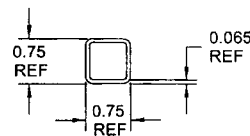
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	DS	D2989	SHEET 3 OF 5
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	<b>BASKET LID ASSEMBLY</b>	NTS
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**D2989-3 RIB**



**D2989-4 RIB**

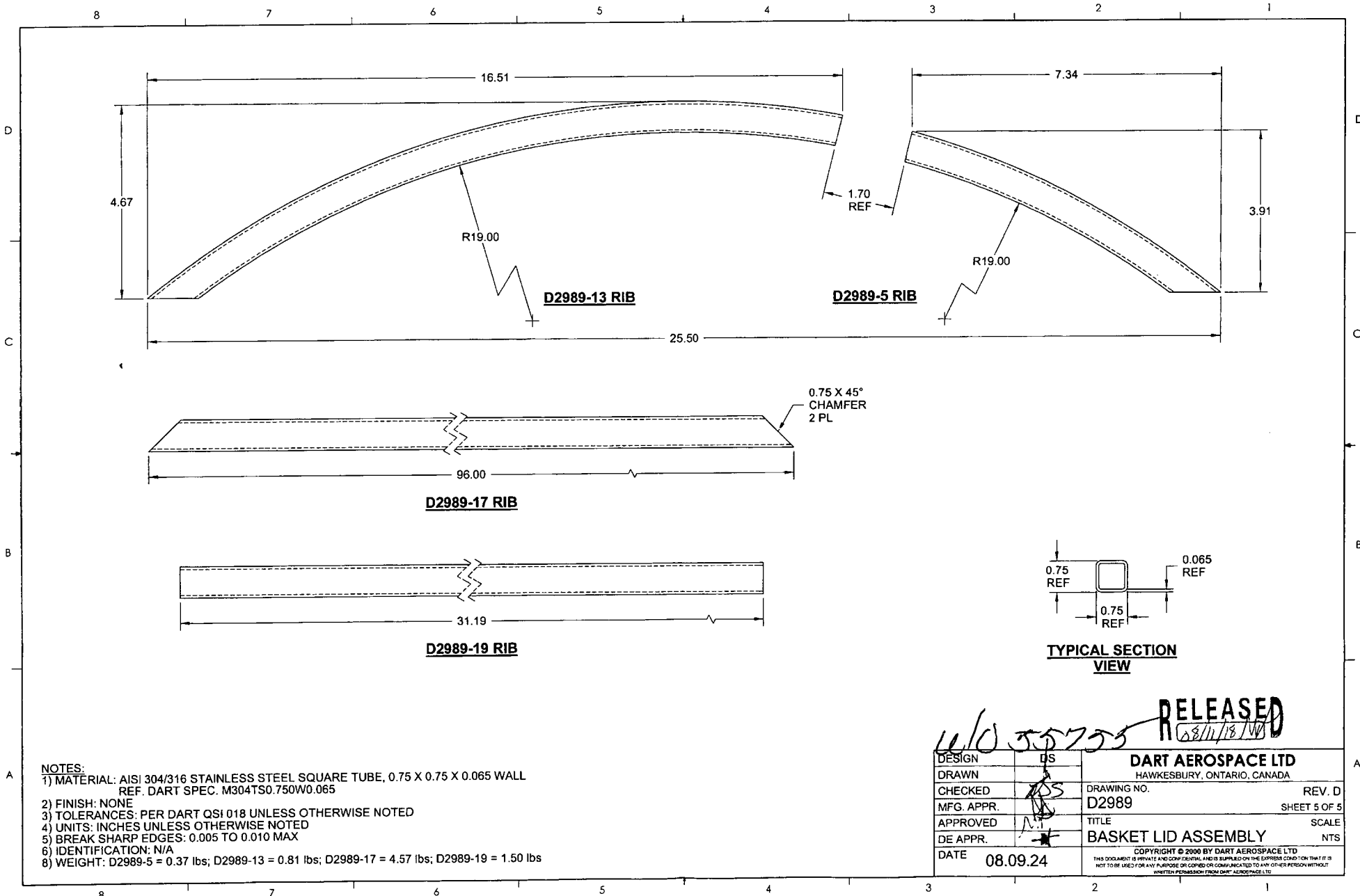


**TYPICAL SECTION  
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

**RELEASED**  
08/11/18 NW

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
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DE APPR.		BASKET LID ASSEMBLY	NTS
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**RELEASED**  
6/10 55755 6/21/18 WJ

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE <b>BASKET LID ASSEMBLY</b>	SCALE NTS
DE APPR.		DATE <b>08.09.24</b>	
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